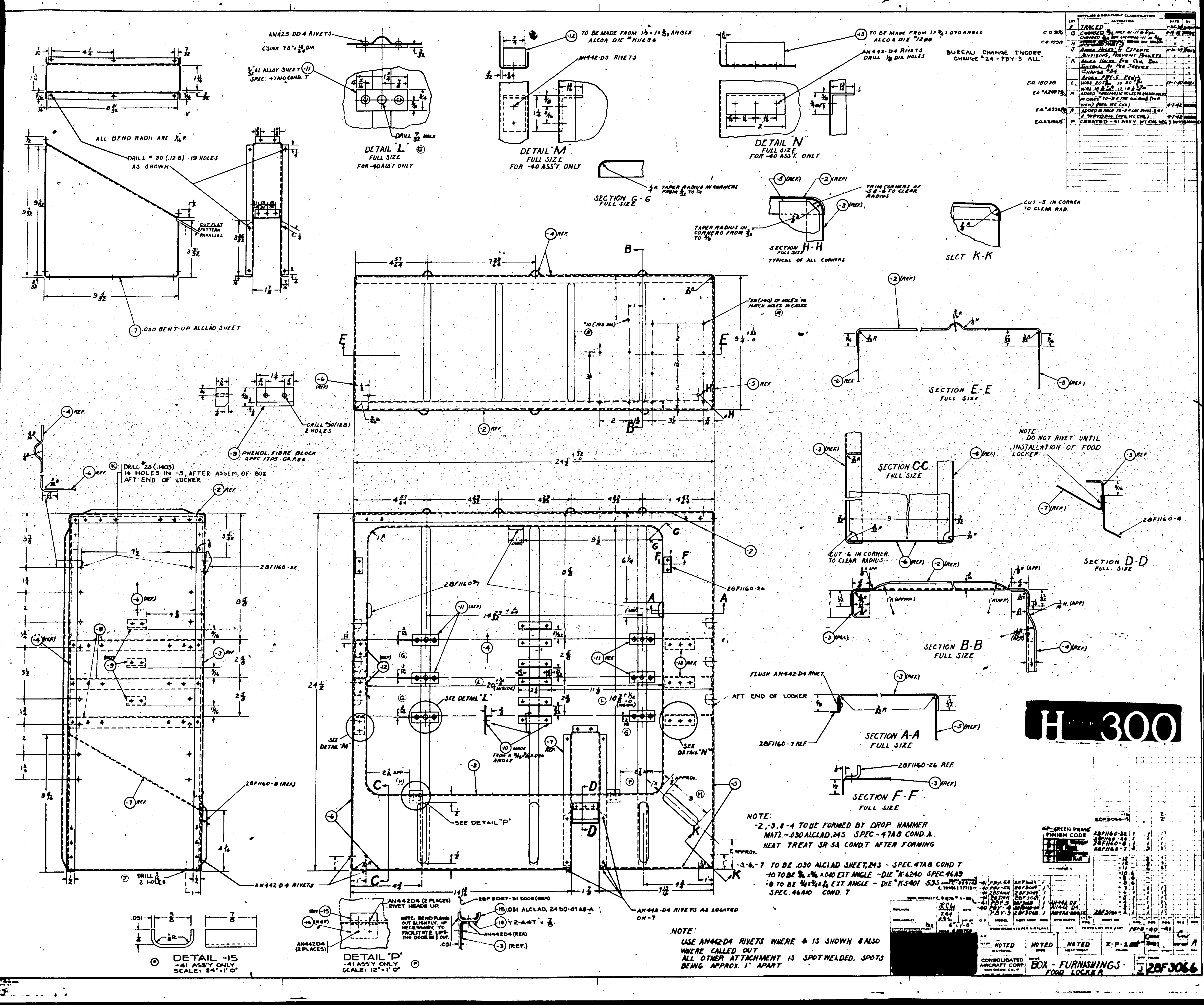

AN425-DD4 RIVETS
C'SINK 78° x 15/64 DIA.
3/32 AL ALLOY SHEET (-11) SPEC. 47A10 COND. T
DRILL 7/32 HOLE
DETAIL "L" (G)
FULL SIZE
FOR -40 ASS'Y. ONLY
(-12) TO BE MADE FROM 1 1/2 x 1 x 3/32 ANGLE ALCOA DIE # K11636
AN442-D5 RIVETS
DETAIL "M"
FULL SIZE
FOR -40 ASS'Y. ONLY
(-13) TO BE MADE FROM 1 x 3/4 x .070 ANGLE ALCOA DIE # 1288
AN442-D4 RIVETS
DRILL 1/8 DIA HOLES
DETAIL "N"
FULL SIZE
FOR -40 ASS'Y. ONLY
BUREAU CHANGE INCORP. CHANGE # 24 - PBY-3 ALL
ALL BEND RADII ARE 1/16" R
DRILL # 30 (.128) - 19 HOLES AS SHOWN
CUT FLAT PATTERN PARALLEL
(-7) .030 BENT-UP ALCLAD SHEET
1/4 R. TAPER RADIUS IN CORNERS FROM 3/32 TO 1/4
SECTION G-G
FULL SIZE
TRIM CORNERS OF -5 & -6 TO CLEAR RADIUS
TAPER RADIUS IN CORNERS FROM 3/32 TO 1/8
SECTION H-H
FULL SIZE
TYPICAL OF ALL CORNERS
CUT -5 IN CORNER TO CLEAR RAD.
SECT. K-K
#28 (.140) 12 HOLES TO MATCH HOLES IN CASES
#10 (.193 DIA.)
SECTION E-E
FULL SIZE
(-9) PHENOL FIBRE BLOCK SPEC. 17P5 GR. F.B.6
DRILL #30 (.128) 2 HOLES
DRILL #28 (.1405) 16 HOLES IN -5, AFTER ASSEM. OF BOX AFT END OF LOCKER
SECTION C-C
FULL SIZE
CUT -6 IN CORNER TO CLEAR RADIUS
NOTE: DO NOT RIVET UNTIL INSTALLATION OF FOOD LOCKER
28F1160-8
SECTION D-D
FULL SIZE
SECTION B-B
FULL SIZE
28F1160-32
28F1160-26
28F1160-7
SEE DETAIL "L"
SEE DETAIL "M"
SEE DETAIL "N"
SEE DETAIL "P"
FLUSH AN442-D4 RIVET
SECTION A-A
FULL SIZE
28F1160-7 REF.
AFT END OF LOCKER
28F1160-26 REF.
SECTION F-F
FULL SIZE
H 300
28F1160-8 (REF.)
AN442-D4 RIVETS
AN442-D4 RIVETS AS LOCATED ON -7
DRILL 3/16 2 HOLES
NOTE:
-2, -3, & -4 TO BE FORMED BY DROP HAMMER
MAT'L - .030 ALCLAD, 24S. SPEC.-47A8 COND. A.
HEAT TREAT SR-53, COND. T AFTER FORMING
-5, -6, -7 TO BE .030 ALCLAD SHEET, 24S - SPEC. 47A8 COND. T
-10 TO BE 3/4 x 3/4 x .040 EXT ANGLE - DIE # K6240 SPEC. 46A9
-8 TO BE 3/4 x 3/4 x 1/16 EXT ANGLE - DIE # K5401 53S SPEC. 46A10 COND. T
28F3067-31 DOOR (REF.)
AN442D4 (2 PLACES) RIVET HEADS UP
NOTE: BEND FLANGE OUT SLIGHTLY, IF NECESSARY, TO FACILITATE LIFTING DOOR IN & OUT.
(-15) .051 ALCLAD, 24SO-47A8-A
(-16) Y2-A4T x 7/8
AN442D4 (REF.)
DETAIL -15
-41 ASS'Y ONLY
SCALE: 24" = 1'0"
DETAIL "P"
-41 ASS'Y ONLY
SCALE: 12" = 1'0"
NOTE:
USE AN442-D4 RIVETS WHERE + IS SHOWN & ALSO WHERE CALLED OUT
ALL OTHER ATTACHMENT IS SPOTWELDED, SPOTS BEING APPROX. 1" APART
CONSOLIDATED AIRCRAFT CORP. SAN DIEGO CALIF.
BOX - FURNISHINGS - FOOD LOCKER
28F3066